

Date: Monday, 2/27/2006 4:18:05 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT		
Job Number	: 25974					
Estimate Number	: 10282					
P.O. Number	: N/A		Part Number	: D2565107		
This Issue	: 2/27/2006 S.O. No. : N/A		Drawing Number	: D2565 REV E		
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: E		
Previous Run	: 24276 Type : SMALL /MED FAB		Material	: N/A		
Written By	: SEE COMMENT BELOW		Due Date	: 3/20/2006 Qty: 20 Um: Each		
Checked & Approved By	: SK 06/02/28					
Comment	: Est:F 02.04.16 Added dwg Rev.C1 NG					

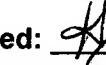
## Additional Product

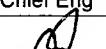
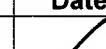
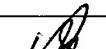
Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M304TR0750W049	304 RD Tube .750 x .049W		
		Comment: Qty.: 1.1751 f(s)/Unit Total : 23.5011 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)	Batch No: M100309	
2.0	BRAKE NC	NC BRAKE		
		Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313		SB 06/03/09
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr		SAP 06/03/12
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		N/A
5.0	QCB	SECOND CHECK		
		Comment: SECOND CHECK		J 06-03-13 16
6.0	POWDER COATING	POWDER COATING		
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3		Q.m 06-03-24 \$60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2565 - 107 PAR #: NA Fault Category: Prod / FAB Ass. med<sup>SMALL</sup> NCR: Yes No DQA:  Date: 06/03/28  
 QA: N/C Closed:  Date: 06.03.28

NCR: 25974		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.03.13	2	2 struts holes are badly damaged, 1 strut is .130 to long from hole to hole, another is $\frac{1}{16}$ " too long.	 	Use $\frac{1}{16}$ " too long per - 111 to replace 1 scrap strut w/025976 Scrap and destroy the other 3.	 06.03.13	 06.03.13	 06.03.13	 06.03.13

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 25974

Part Number: D2565107

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 185

DOCUMENT CONTROL

Po 4/3/27 (16)

9.0 DC



Comment: DOCUMENT CONTROL

Inspection Level 21

(16) 06/03/28

Job Completion



u 06-03-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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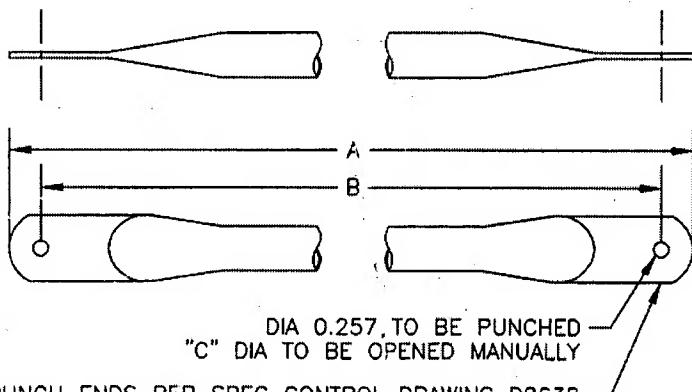
NOTE: Date & initial all entries



COPY ISSUED  
DATE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE		TITLE	SCALE
04.05.05		STRUT	1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED  
04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 WITHOUT NOTICE
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WORK ORDER

NO: 25174

